

Work Order ID 51201

August 7, 2009 2:19:50 PM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: M109213

Pl 09.08.20

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 09.08.20

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Item Name: Basket Lid Assembly

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Work Order ID 51201

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Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4 ()

Spray Paint Black: () ()

Wing Walk: ()

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

*DO NOT PAINT**ENB- SEE ATTACHED EMAIL*

[illegible]

August 7, 2009 2:19:50 PM



[illegible][illegible]

Customer:

1101



Date:

[illegible]

L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: August 7, 2009 11:42 AM
To: 'L Lacelle'; 'Melanie Fauteux'
Cc: 'Alan Stocker'; 'Dan Stow'
Subject: Two basket lids

Mel/Linda

Por favor...

We need two AS350 basket lids. We need a SHORT basket – full lid, and a Long Basket Split Lid....We'll try to be careful with them so that they can be returned to inventory when we're done....(not powder-coated)

No hurry.....sometime in the next couple of weeks.

Thanks

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

8/07/09

Work Order ID 51201



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Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/21/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD308

U-10-03-4

Picklist Print

August 7, 2009 2:19:49 PM

Work Order ID: 51201

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 8/10/09

Required Date: 8/21/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-I RevH		Manufactured	No			100	Each	5.0000	2.0000			

Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

48101

1

48427

4

D2506RevF

Manufactured

No

100

Each

3.0000

1.0000

Label Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

3

44275

1

50027

2

D2512-7RevE

Manufactured

No

100

Each

8.0000

1.0000

Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

8

43987

1

44865

1

48326

2

48666

4

Cpl 09-08-17 ✓

B51135 → Cpl 09-08-17 ✓

Cpl 09-08-17 ✓

Picklist Print

August 7, 2009 2:19:49 PM

Work Order ID: 51201



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	49.0000	2.0000			
Mounting Bracket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

46086 2

48428 3

Main Warehouse

WA 44

50872 44

Pp10908.17 ✓

D2989-13RevD

Manufactured No

100 Each

8.0000

2.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 8

48452 4

50579 4

Pp10908.17 ✓

Picklist Print

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Page 3

Work Order ID: 51201

Parent Item: D2989-041RevD

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 8/10/09

Required Date: 8/21/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2989-19RevD

Manufactured

No

100

Each

9.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

44867

1

47976

2

48102

2

50823

4

Plc 09.08.17 ✓

D3832-3RevA

Manufactured

No

100

Each

5.0000

1.0000



Mesh (Lid)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

47747

2

48608

3

Plc 09.08.17 ✓

D3833-3RevA

Manufactured

No

100

Each

11.0000

2.0000



Mesh (Lid End)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

46308

11

Plc 09.08.17 ✓

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Shop Packet Print

Page 3

Picklist Print

August 7, 2009 2:19:49 PM

Work Order ID: 51201



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3836-041RevA		Manufactured	No			100	Each	4.0000	1.0000			

Rib Assembly (Basket Lid, LH)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

48440

2

Main Warehouse

WA

2

50578

2

Pp09.08.17 ✓

D3836-042RevA

Manufactured

No

100

Each

4.0000

1.0000



Rib Assembly (Basket Lid, RH)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

48441

2

Main Warehouse

WA

2

50577

2

Pp09.08.17 ✓

Picklist Print

August 7, 2009 2:19:49 PM

Work Order ID: 51201



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 8/10/09

Required Date: 8/21/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3852-041RevA		Manufactured	No			100	Each	4.0000	1.0000			

Rib Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
48098	2	
50580	2	

D3852-042RevA

Manufactured

No

100

Each

4.0000

1.0000



Rib Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
48097	2	
50581	2	

Op 08.08.17 ✓

Op 09.08.17 ✓

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

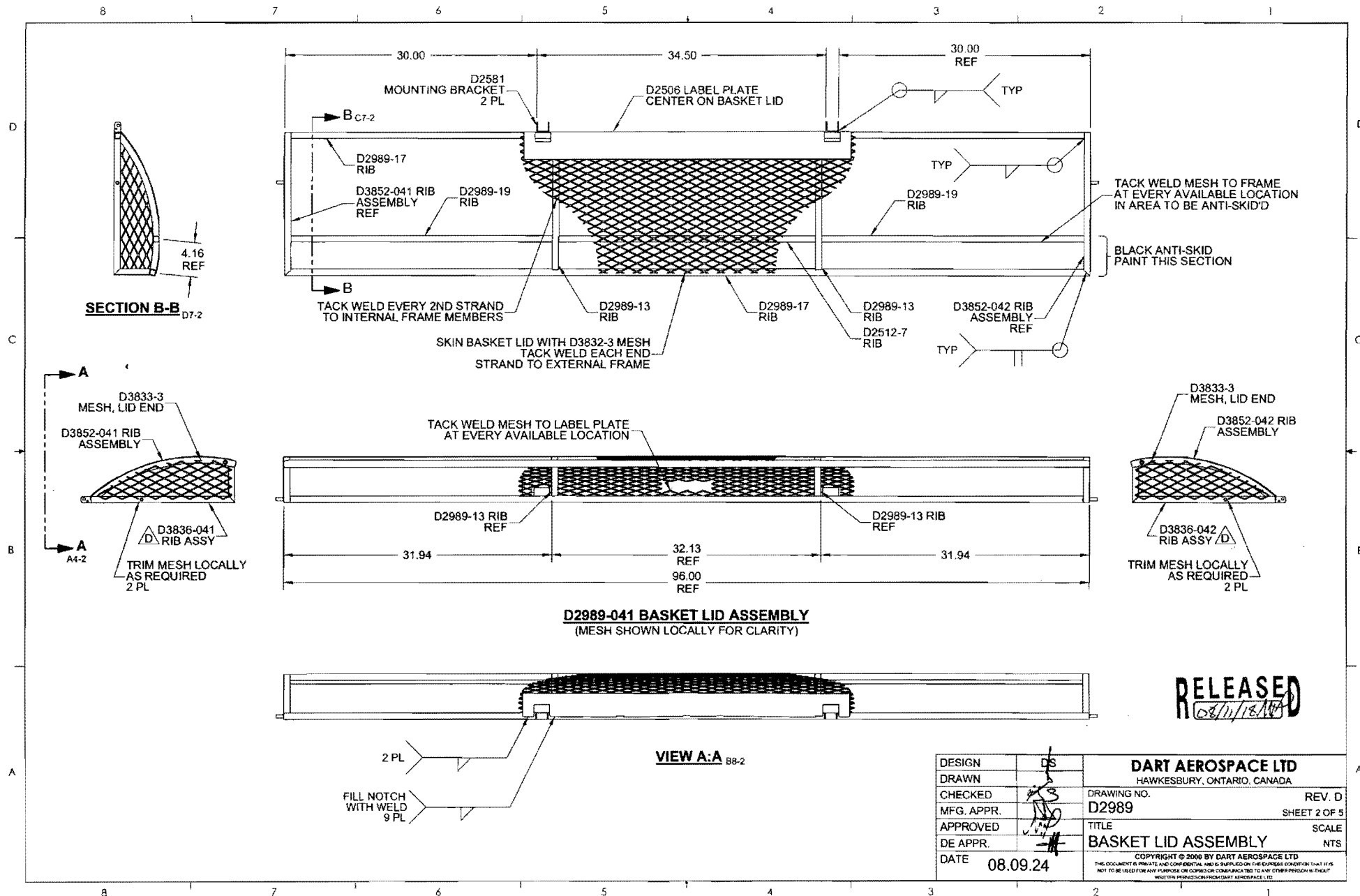
NOTES:

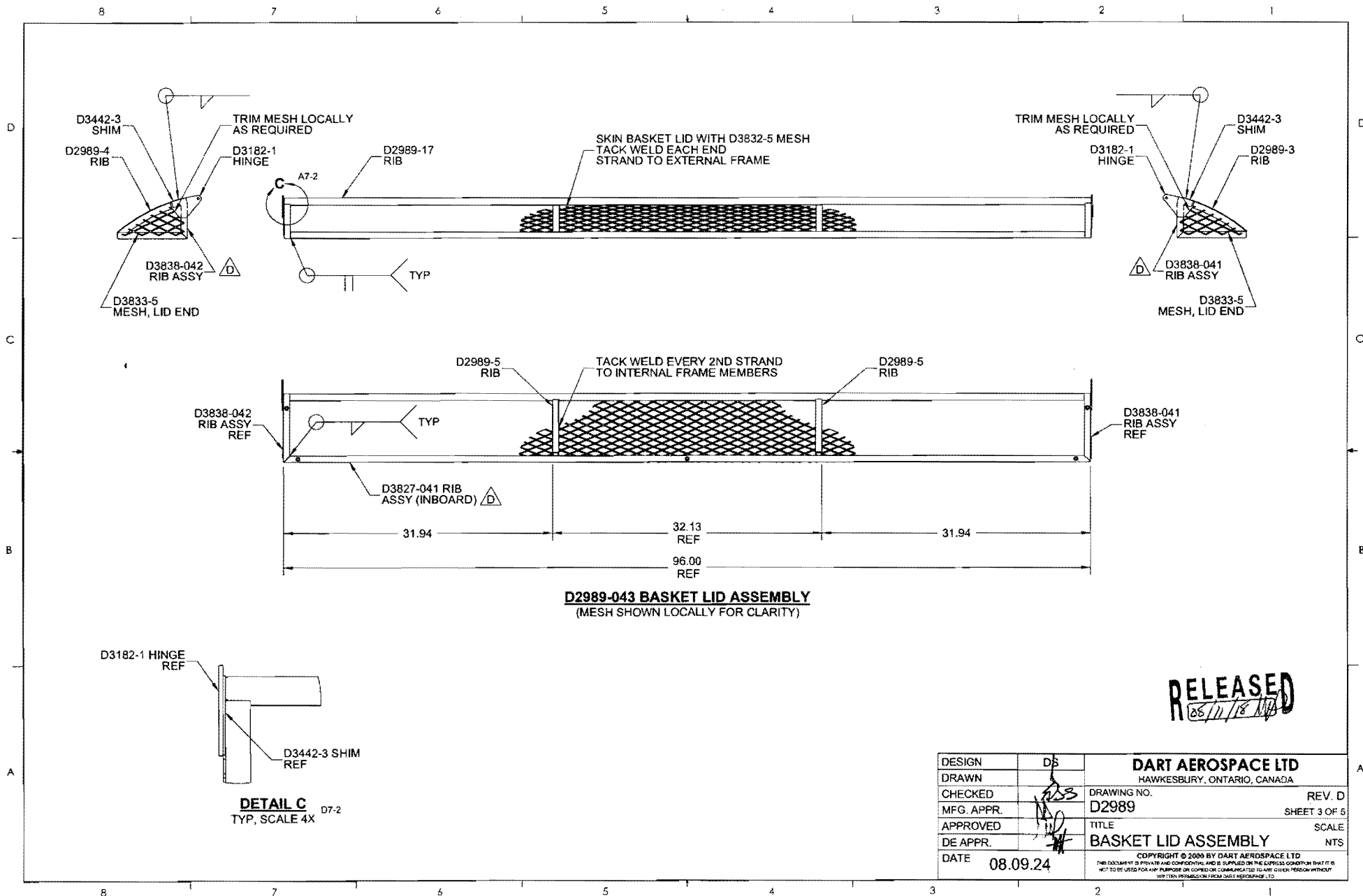
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

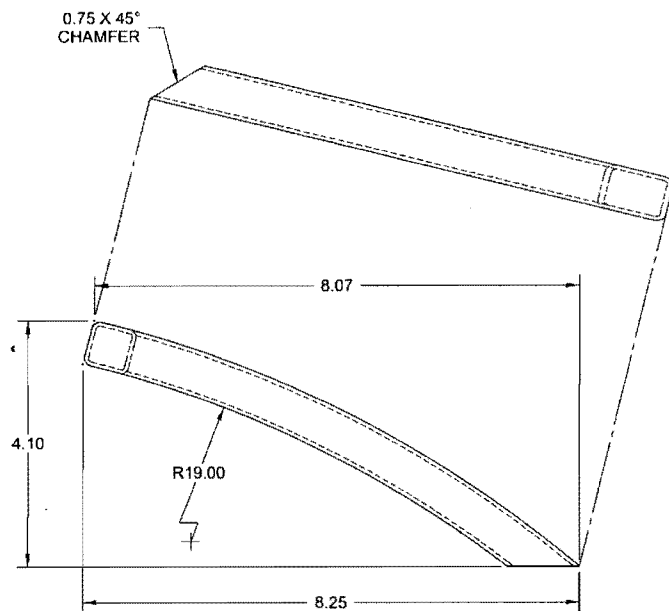
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2508	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/15

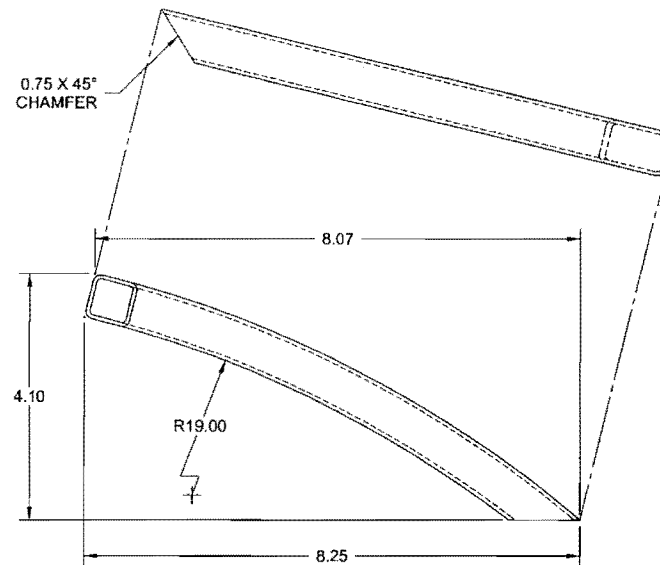
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	OS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



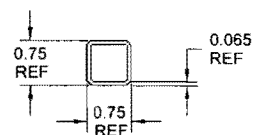




D2989-3 RIB






D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NUP

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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